

Work Order ID 64528

Tuesday, December 07, 2010 11:36:27 AM



SHIP DEC. 20th

Page 1

Item ID:	D3197-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bar Assembly					
Start Date:	12/8/2010	Start Qty:	8.00			
Required Date:	12/15/2010	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>10-12-06</i>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3197	Rev B								
100	BAND SAW	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 29.125" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

SL 10/12/14

SL 10/12/15 *(8)*

SL 10/12/15

8 *2*

8

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Item ID: D3197-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar Assembly

Start Date: 12/8/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00

Customer:


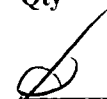




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.00				8			
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8		10-12-16	



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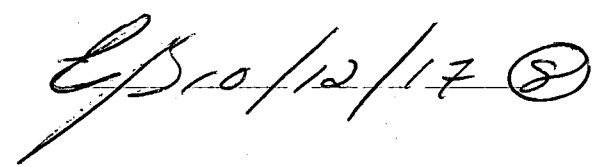
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Item ID: D3197-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bar Assembly
Start Date: 12/8/2010 Start Qty: 8.00  Cust Item ID:
Required Date: 12/15/2010 Req'd Qty: 8.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 112588</i> Memo START TIME: <i>2:15</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>3:15</i>	0.00 0.00				<i>8</i>		<i>BR 10-12-16</i>	
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>M</i>	<i>10112117</i>		<i>8</i>	<i>0</i>		
180  Small Fab Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.00							<i>LP 10/12/17</i> 

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Item ID: D3197-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar Assembly

Start Date: 12/8/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/12/17



200

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

C 12/4/17 8

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/17 9
C 10/12/17

Picklist Print

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Page 1

Work Order ID: 64528

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 12/8/2010

Required Date: 12/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

* AN960JD10 NAS1149D0363J Purchased

No

180

Each

8.0000

6

48

Washer

LD M115622 (48x)

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

D2690-5

Manufactured

No

180

Each

6.0000

2

16

Lanyard Assembly

Location

Loc Qty

Loc Code

ST021

6

60215

6

* D3242-1

Manufactured

No

180

Each

6.0000

2

16

Tag

Location

Loc Qty

Loc Code

ST047

6

64104

6

D3489-3-200

Manufactured

No

180

Each

2.0000

2

16

PIP PIN

Location

Loc Qty

Loc Code

ST62

2

61419

2

EP 10/12/17

EP 10/12/17
B64533 (10x)

EP 10/12/17
B64531 (4x)

EP 10/12/17
B60139 (6x)

EP 10/12/17
B64532 (15x)

Picklist Print

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Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 12/8/2010

Required Date: 12/15/2010

Start Qty: 8.00

Required Qty: 8.00

M7075T73R1.000 Purchased No

180 f

8.7050 2.42 20.37895



7075-T73 Rd Bar 1.00



SA 10/12/14

Location

Loc Qty

Loc Code

MAT

8.705

20 Pt

115165

8.705

MS21042L3 Purchased No

180 Each

1,213.000 2 16



Nut



5/10/12/17

Location

Loc Qty

Loc Code

ST300

1213

(112) M116373

114784

217

5

115835

996

MS27039-1-24 Purchased No

100 Each

115.0000 2 16



Screw



5/10/12/17

Location

Loc Qty

Loc Code

ST292

115

16

100151

115

096

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓		m-tape	
25.06	+/-0.030	25.06	✓		"	
11.44	+/-0.030	11.450	✓		vern CNG-02	
0.500	+/-0.010	.503	✓		vern SL-3	
0.250	+/-0.030	.265	✓		"	
Ø0.219	+0.005/-0.000	.219	✓		"	
Ø0.191	+0.005/-0.000	.192	✓		"	
1.000	+/-0.005	1.000	✓		"	
2.69	+/-0.030	2.689	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.300	+/-0.010	.295	✓		"	
0.063 x 45°	+/-0.010	.058 x 45°	✓		"	
Ø1.000	+/-0.010	.999	✓		"	

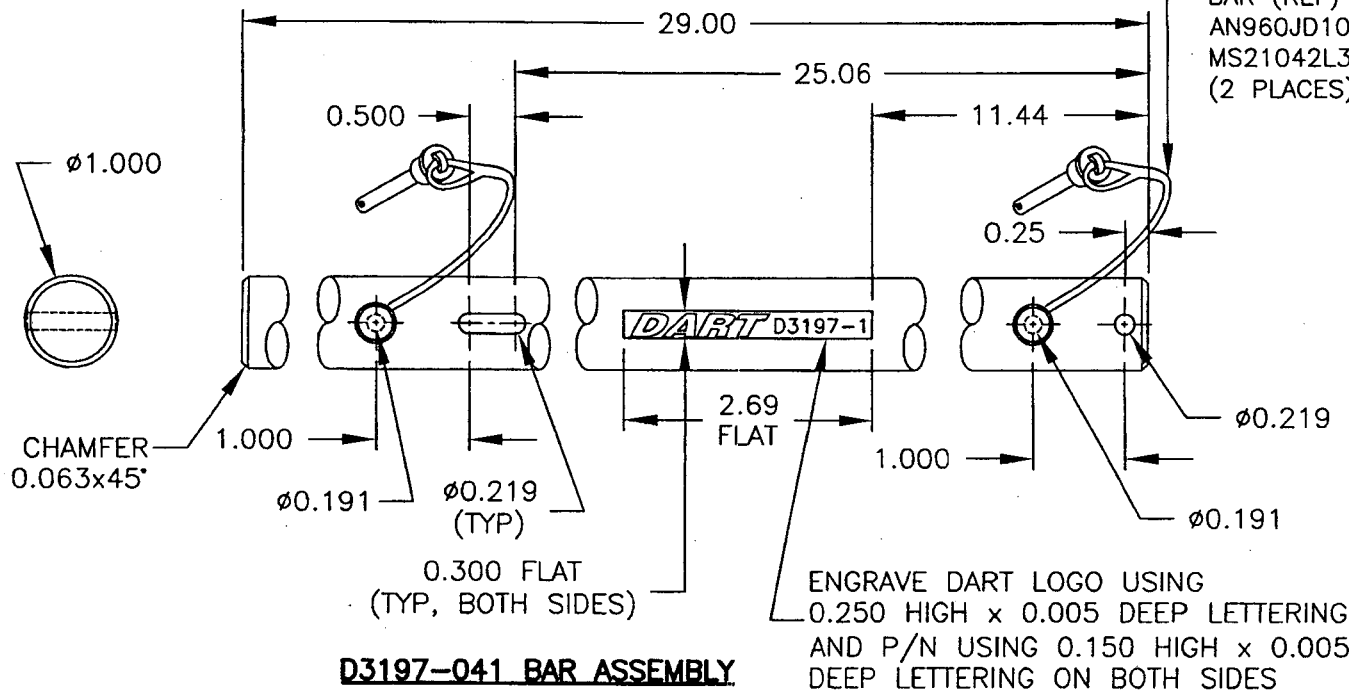
Measured by: SL	Audited by: MR	Prototype Approval:	N/A
Date: 10/12/15	Date: 10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	BE

RELEASED
000321 UP
JUN 20 1982

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3197
DATE 06.01.10				SHEET 1 OF 1
				SCALE 1:1
A		03.07.01		NEW ISSUE
B		06.01.10		CHG PIP PIN; ADD D3242-1 TAG

#64528